

Work Order ID 164283

Monday, July 17, 2017 9:19:57 AM

164283

Page 1

Item ID: D3774-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Bottom, LH/RH
Start Date: 7/21/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JUL 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 3-88 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3774	Rev B								

110		0.00							<u>DAS</u>
110	THERMOFORMING MACHINE					<u>2</u>	<u>JUL 19 2017</u>		<u>13</u>

Purchasing	Memo	0.00							
Purchasing	ISSUE P/O: <u>37108</u>								
	SUPPLIER: PLASTECH								

MANUFACTURE D3774-1 AS PER DWG

C OF C IS REQUIRED

140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140	HAND FINISHING THERMOFORMING								

Packaging	Memo	0.00							
Packaging									

2x 80178-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 164283

Monday, July 17, 2017 9:19:57 AM

164283

Page 2

Item ID: D3774-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Seat Bottom, LH/RH

Start Date: 7/21/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/4/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC6- All purchased or subcontracted products

0.00

150

QC

Memo

0.00

Quality Control

2 17-09-20 80

170

Identify as per dwg & Stock Location: 51250 0.00***170***

Packaging

Memo

0.00

Packaging

2 0.00 SEP 20 2017

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

17/9/21 [Signature][Signature] SEP 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

Picklist Print

Monday, July 17, 2017 9:20:00 AM

Page 1

Work Order ID: 164283

164283

Parent Item: D3774-1

D3774-1

Parent Item Name: Seat Bottom, LH/RH

Start Date: 7/21/2017

Required Date: 8/4/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL IPP Rev. C
Add Step 105 Dry Material 10/04/21 DL IPP Rev.D 17.06.13
Now outside process DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3774-1P		Purchased	No			110	Each	0.0000	1	2			
D3774-1P									**				
Seat Bottom, LH/RH													

2x Sp 17-8-30

17.07.17 MLEXS .125-FG0029-04
(dark grey)

Batch: _____ qty per kit 10.67 SF

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No.: _____ NCR No.: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order: 164283
Description: Seat Bottom		Part Number: D3774-1
Inspection Dwg: D3774	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: OK

Date: 17/08/07

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.32"	✓			
33.9	+/-0.100	33.8"	✓			
17.4	+/-0.100	17.4"	✓			
0.085	Min	0.091"	✓			
0.100	Min	0.106"	✓			
0.100	Min	0.112"	✓			
0.100	Min	0.116"	✓			
0.100	Min	0.112"	✓			

Measured by: DAS 07 9-09

Date: 17/09/07

Audited by: PD

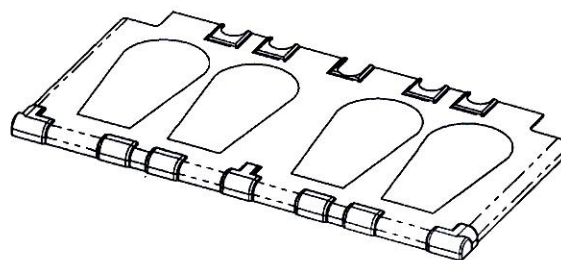
Date: 17-09-07

Prototype Approval:

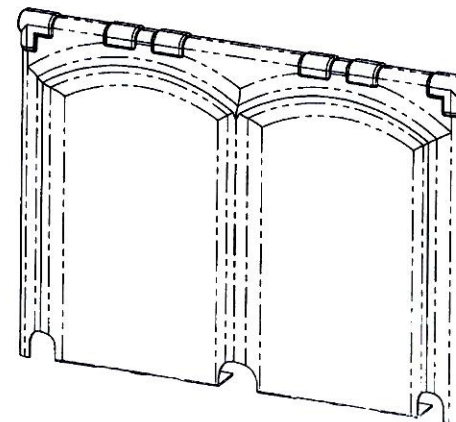
Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 164283 H.C.
 170717



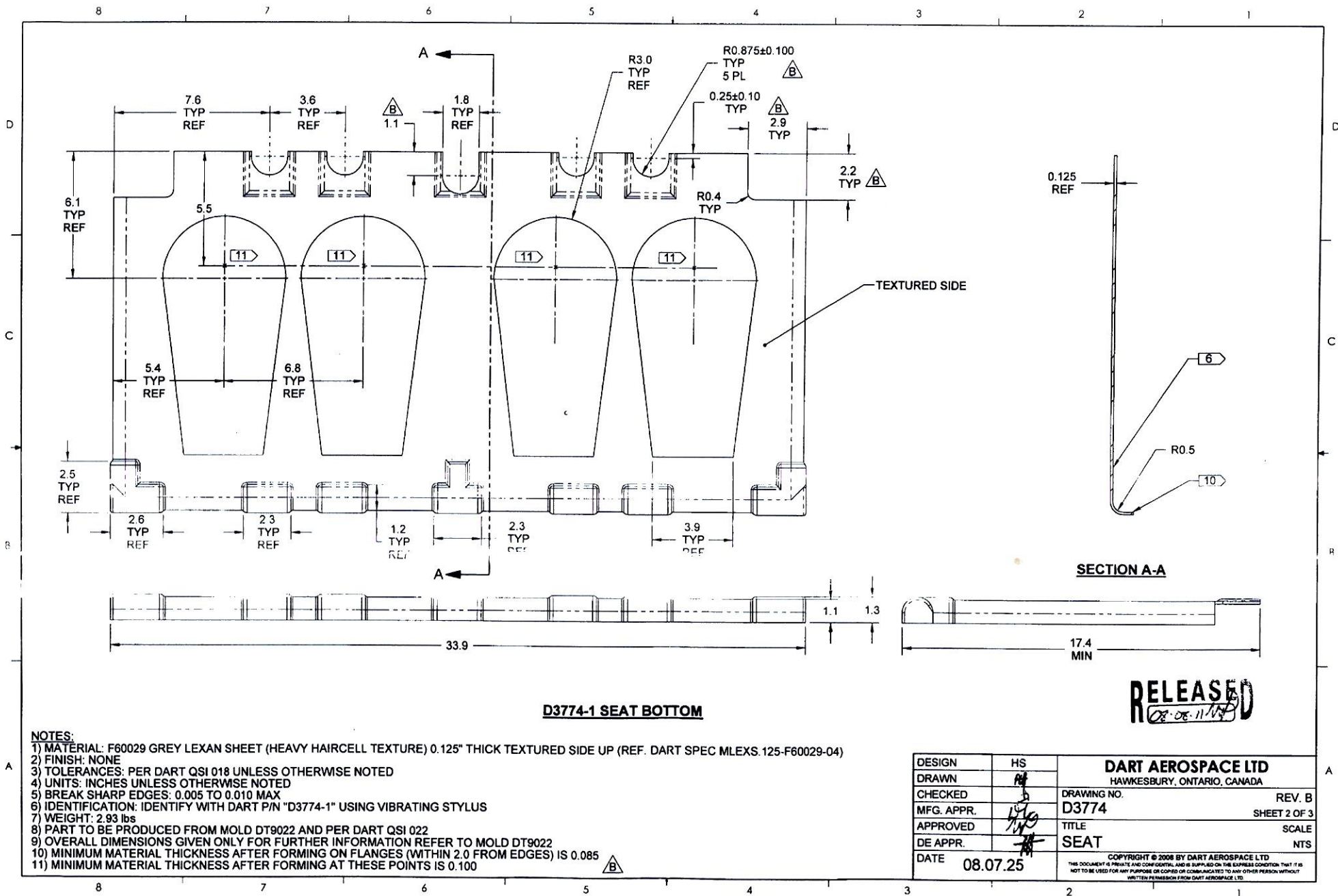
D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

RELEASED
 08-11-17

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3774 TITLE SEAT REV. B SHEET 1 OF 3 SCALE NTS	
DRAWN	PH		
CHECKED	S		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	DATE 08.07.25 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3774	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37108**

Purchase Order Date 7/19/2017

PO Print Date 7/19/2017

Page Number 4 of 9

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Total: \$400.00

10	D3874-2L02P	Floor Protector - Pilot Black	7/31/2017	FN	4.00	\$100.00	\$400.00
			Yes		Each		
			7/31/2017				

MANUFACTURE AS PER DWG D3874 REV. B
B164286

Line Total: \$400.00

11	D3774-1P	Seat Bottom, LH/RH	7/31/2017	FN	2.00	\$100.00	\$200.00
			Yes		Each		
			7/31/2017				

MANUFACTURE AS PER DWG D3774 REV. B
B164283

Line Total: \$200.00

12	D3774-3P	Seat Back, LH/RH	7/31/2017		2.00	\$100.00	\$200.00
			Yes		Each		
			7/31/2017				

MANUFACTURE AS PER DWG D3774 REV. B
B164284

Note:

7/19/2017

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 24077
Shipment Date: 08/25/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 2

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order
37108
Carrier Account #
CU103666

Sales Order
SO-019288

Incoterms
EX WORKS

Ship Via
FREIGHTCOM INC. -

Payment Method
PPD/CHG
Tracking Number

Item Number - Revision	Description	Quantity Shipped	UOM
D3676-1 - Rev.: D	FULL HEIGHT BUBBLE WINDOW (LH) AS PER DWG D3676 REV. D HS Code: 3920.51.1000 - OTHER Country of Origin : CA	2	EA
D4941-1L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D4941-2L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D4941-3L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D4941-4L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D3874-1L02 - Rev.: B	FLOOR PROTECTOR CO-PILOT BLACK AS PER DWG D3874 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D3874-2L02 - Rev.: B	FLOOR PROTECTOR PILOT BLACK AS PER DWG D3874 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D3774-1 - Rev.: B	SEAT BOTTOM AS PER DWG D3774 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D3774-3 - Rev.: B	SEAT BACK AS PER DWG D3774 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA

SPA-8-30

2 EA

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37108 SO # 019288

Part #	D3676-1	Qty.	2	Batch #	-001
Description	FULL HEIGHT BUBBLE WINDOW LH 2 SHEETS 891754				
Part #	D4941-1L02	Qty.	2	Batch #	
Description	CABIN FLOOR PROTECTORS 1 SHEET M129722				
Part #	D4941-2L02	Qty.	2	Batch #	-006
Description	CABIN FLOOR PROTECTORS OFF CUT M129722				
Part #	D4941-3L02	Qty.	2	Batch #	-007
Description	CABIN FLOOR PROTECTORS OFF CUT M129722				
Part #	D4941-4L02	Qty.	2	Batch #	-008
Description	CABIN FLOOR PROTECTORS 1 SHEET M129722				
Part #	D3874-1L02	Qty.	4	Batch #	-009
Description	FLOOR PROTECTOR CO-PILOT BLACK OFF CUT M129722				
Part #	D3874-2L02	Qty.	4	Batch #	-010
Description	FLOOR PROTECTOR PILOT BLACK 1 SHEET M129722				
Part #	D3774-1	Qty.	2	Batch #	-011
Description	SEAT BOTTOM 1 SHEET M137737				

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: AUG 25, 2017 COFC # 005
(Approved QA Signatory)

Page: 1 of 2

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37108 SO # 019288

Part #	D3774-3	Qty.	2	Batch #	-012
Description	SEAT BACK	Material usage	1 SHEET	Lot#	M137737
Part #	D4634-1P	Qty.	4	Batch #	-013
Description	FWD CENTER CEILING PANEL	Material usage	2 SHEETS	Lot#	M135517
Part #	D4634-3P	Qty.	3	Batch #	-014
Description	MIDDLE CENTER CEILING PANEL	Material usage	2 SHEETS	Lot#	M135517
Part #	D4634-5P	Qty.	4	Batch #	-015
Description	AFT CENTER CEILING PANEL	Material usage	2 SHEETS	Lot#	M135517
Part #	D4635-1	Qty.	3	Batch #	-016
Description	FWD CEILING PANEL, LH	Material usage	3 SHEETS	Lot#	M135517
Part #	D4635-2	Qty.	3	Batch #	-017
Description	FWD CEILING PANEL, RH	Material usage	3 SHEETS	Lot#	M135517
Part #	D4635-3	Qty.	3	Batch #	-018
Description	AFT CEILING PANEL, LH	Material usage	OFFCUT	Lot#	M135517
Part #	D4635-4	Qty.	3	Batch #	-19
Description	AFT CEILING PANEL, RH	Material usage	OFFCUT	Lot#	M135517

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN
(Approved QA Signatory)

Date: AUG. 25, 2017 COFC# 005

Page: 2 of 2

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plastechnonline.com, Web: www.plastechnonline.com